

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021143**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 14E / Bay 14

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Segment 14E Deck Panel diaphragm welds as per ZPMC notification # 08385.

The weld designations reviewed are as follows:

DP3158-001-244~257, 262~265, 270~273, 278~281

DP3158-001-286~295, 296~299, 304~307, 312~315, 320~323

DP3158-001-328~332, 333~337

OBG Segment 13CE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of Deck Panel diaphragm weld # SEG3011G-008. The welder is identified as 037705. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables

## WELDING INSPECTION REPORT

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recorded by QC appeared to comply with WPS-B-T-2233\_ESAB.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of AP to BP repair weld # SEG3019U-003, as per B-WR # 20270. The welder is identified as 066418, 054013 and 044779. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair. See attached photograph Pic\_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of DP diaphragm repair weld # DP3160-001-041, as per B-WR # 20272. The welder is identified as 067656. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair.

OBG Segment 14E / Bay 14

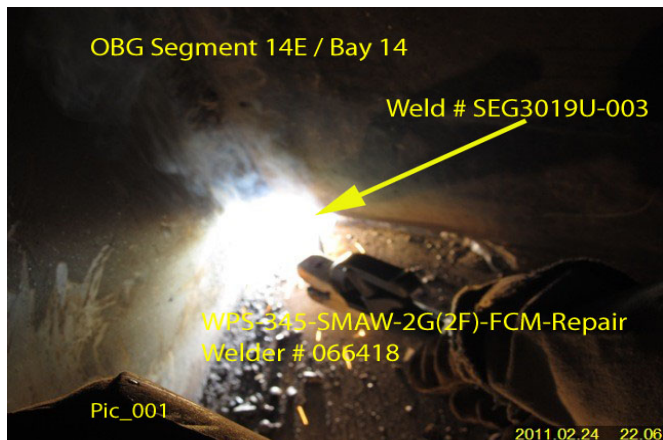
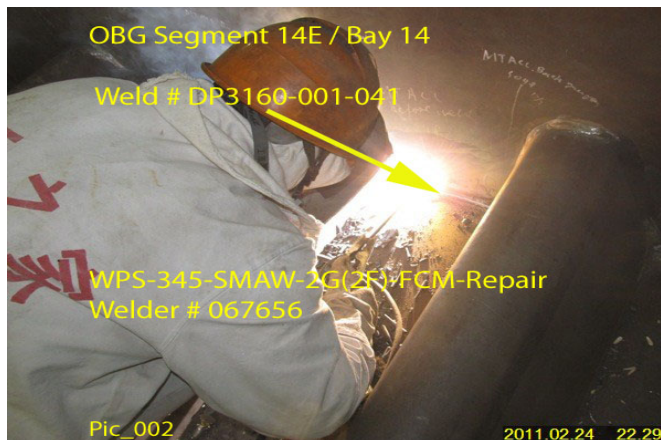
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of DP diaphragm repair weld # DP3161-001-213, as per B-WR # 20250. The welder is identified as 037932. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of DP diaphragm repair weld # DP3161-001-019, as per B-WR # 20267. The welder is identified as 050969. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-Repair. See attached photograph Pic\_002.



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### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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